Monday, 6/5/2006 7:47:04 AM

User:

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 27363

Estimate Number

: 10498

P.O. Number

Prsht Rev.

First Issue

AIL:

: NC

This Issue

: 6/5/2006

: N/A

: 26921

S.O. No. : NA

: LANDING GEAR

Drawing Name

Part Number

: D2739 : D2739 REV C

: WEB

Drawing Number

: N/A Project Number **Drawing Revision**

Material **Due Date**

: 6/26/2006

Qty:

5 Um:

Each

Written By

Checked & Approved By

Comment

Previous Run

Reformat

Est Rev: D

06-03-21 As Per Rev C JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D26005108

Extrusion 'I Beam' thin



Comment: Qty.:

Total: 1.0000 Each(s)/Unit

5.0000 Each(s)

Extrusion 'I Beam' thin

Qty Part Number D2600-5

Description Batch

\$ 06-06-16



2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1







Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

27 06-06-16

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 27 06-06-16 1

3-Use uni-bit to open holes to finish size as per Dwg D2739.

06-06-16(9)

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. 27 06 - 06 - /60

5-Dburr

3.0

QC5

INSPECT WORK TO CURRENT STEP



06-6-20



Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Annroyal					
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector				
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Part No:	PAR #:	Fault Category: No	CR:	Yes No DQA:	Date: 06/06/21
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Monday, 6/5/2006 7:47:04 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: WEB Customer: CU-DAR001 Dart Helicopters Services Part Number: D2739 Job Number: 27363 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 4.0 Comment: HAND FINISHING RESOURCE #1 06-06-20 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 5.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 6.0 Comment: PACKAGING RESOURCE #1 Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web. Identify and Stock Location: L DC 7.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES		·			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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	A Comment						ii.

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section B	Verification	Annroyal	Annroval	
DATE STEP		Section A	Initial Action Description Sign Design Mgr Dasign Mgr Dasi			Section C	Approval Design Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA: _	·	Date: 🗺	<u> </u>
NOTE: Date & initial all entries				QA:	N/C C	losed: _		∬Date:	***
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DRAWN BY DESIGN AEROSPACE USA, INC. DART PH PH REV. C DRAWING NO. CHECKED APPROVED SHEET 1 OF 1 D2739 SCALE TITLE DATE 0 06.01.05 **WEB** 1:15 98.04.16 **NEW ISSUE** AC

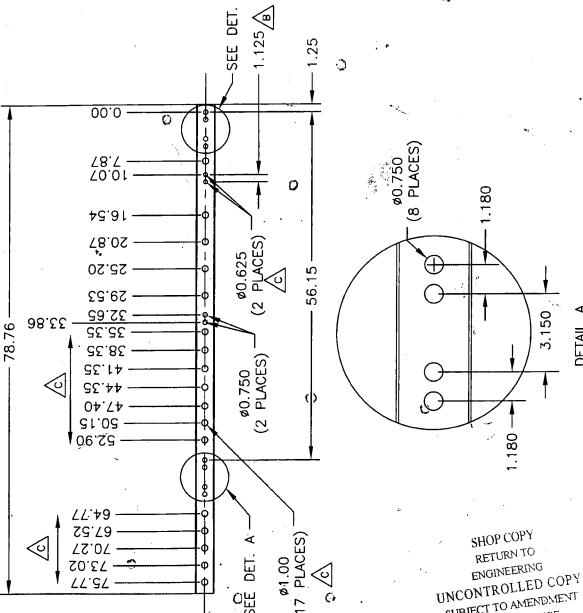
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4

CHANGE HOLES FOR COMPATABILITY В 98.11.18 WITH AIRCRUISER FLOATS ADD/MOVE HOLES FOR COMPATABILITY, 06.01.05 C W/APICAL FLOATS

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SUBJECT TO AMENDMENT WITHOUT NOTICE

ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI MATERIAL D2739 **2**2254

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MAKE FROM D2600-5 EXTRUSION

ACID ETCH, ALODINE PER DART

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